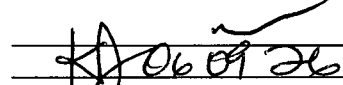
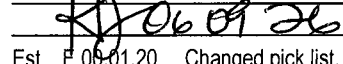


Date: Tuesday, 9/26/2006 3:39:27 PM
User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : 205 BEARPAW INSTALLATION KIT (48")
Job Number : 28729	
Estimate Number : 12283	
P.O. Number : N/A	Part Number : D205564011
This Issue : 9/26/2006 S.O. No. : N/A	Drawing Number : D2521 REV J
Prsht Rev. : NC	Project Number : N/A
First Issue : 9/26/2006 Type : MACHINED PARTS	Drawing Revision : J
Previous Run : N/A	Material : N/A
Written By : 	Due Date : 10/10/2006 Qty: 6 Um: Each
Checked & Approved By : 	
Comment : Est F 06-01-20 Changed pick list, MPP 2019, CHG006 EC Est Rev:G 06-08-28 As per Rev E JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	DC	DOCUMENT CONTROL
-----	----	------------------



Comment: DOCUMENT CONTROL

Photocopy blue file and type labels per PPP D205-564-011 CHG007

KS 06-10-03

⑥

2.0	MUHMWB10	UHMW 1" Black
-----	----------	---------------



Comment: Qty.: 13.6500 sf(s)/Unit Total : 81.9000 sf(s)
blank: 19.500" x 48.0" x 1.00" thick (+0.030/-0.000) per DSK086-6
Material: Black UHMW 1"
(MUHMWB10)
Batch: 102164

J.F. 06/10/04

⑥

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
-----	-------	--------------------------------



Comment: HAAS CNC VERTICAL MACHINING #1
(2) Bearpaws Make (1) kit

1-Inspect material for defects or damage prior to machining

2-Machine as per Folio and Dwg D2521 Identify as D2521

3-Deburr

J.F. 06/10/04

P40

⑥

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

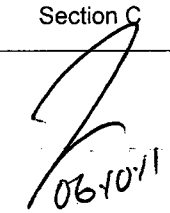
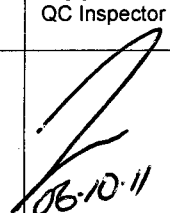
J.F. 06/10/07

⑥

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: DP Date: 06/10/11
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
06.10.05	3	WRONG HOLES USED TO CLAMP PART - PROFILE OF BEARPAW SHIFTED ON TOP IN RELATION TO HOLES	GP 06.10.05 pw QS1642	Quarantine Part. Replace.		 06.10.11	GP 06.10.05 pw QS1642	 06.10.11

NOTE: Date & initial all entries

Date: Tuesday, 9/26/2006 3:39:27 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 205 BEARPAW INSTALLATION KIT (48")

Job Number: 28729

Part Number: D205564011

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

SA 06.10.07

6.0

D2182B055

Clamp Cushion, Black



Comment: Qty.: 8.0000 Each(s)/Unit Total : 48.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

8 D2182B055 Rubber Cushion

B28042

PAO S.R.

7.0

D2274

Radius Block



Comment: Qty.: 20.0000 Each(s)/Unit Total : 120.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

20 D2274 Radius Block

B28824

PAO S.R.

8.0

D2529

Washer



Comment: Qty.: 20.0000 Each(s)/Unit Total : 120.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

20 D2529 Washer

B27876

9.0

D2947

Clamp



Comment: Qty.: 8.0000 Each(s)/Unit Total : 48.0000 Each(s)

Clamp

Pick:

Qty Part Number Description Batch

8 D2947 Clamp

B25770

10.0

D3544041

CLAMP



Comment: Qty.: 4.0000 Each(s)/Unit Total : 24.0000 Each(s)

CLAMP

Batch: B28796

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 9/26/2006 3:39:28 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 205 BEARPAW INSTALLATION KIT (48")

Job Number: 28729

Part Number: D205564011

Job Number:



Seq. #:

Machine Or Operation:

Description :

11.0

AN413A

Bolt



Comment: Qty.: 8.0000 Each(s)/Unit Total : 48.0000 Each(s)

Bolt

Batch: M101938~

12.0

AN415A

Bolt



Comment: Qty.: 20.0000 Each(s)/Unit Total : 120.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

✓ 16 AN4-15A Bolt M102039~

13.0

AN960JD416

Washer



Comment: Qty.: 20.0000 Each(s)/Unit Total : 120.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

✓ 20 AN960JD416 Washer M19185~

14.0

MS21042L4

Nut



Comment: Qty.: 20.0000 Each(s)/Unit Total : 120.0000 Each(s)

Nut

✓ Batch: M15099~

15.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

16.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: Dev B

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 9/26/2006 3:39:28 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 205 BEARPAW INSTALLATION KIT (48")

Job Number: 28729

Part Number: D205564011

Job Number:



Seq. #:

Machine Or Operation:

Description :

17.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

S

06/10/11

Job Completion



11 06/10/11

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	28729
Description: Bearpaw		Part Number:	D2521
Inspection Dwg: D2521 Rev: J		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Inspection Sheet Drawing Dimension			Actual Dimension	Accept	Reject	Method of Inspection	Comments
Dim	Min	Max					
A	0.260	0.266	0.260	—			
B	0.90	0.96	0.934	—			
C	0.27	0.330	0.304	—			
D	0.470	0.530	0.500 x 15°	—			
E	21.740	21.760	21.750	—			
F	0.72	0.780	0.750	—			
G	0.35	0.410	0.385	—			
H	11.490	11.570	11.500	—			
I	3.41	3.47	3.427	—			
J	11.790	11.810	11.800	—			
K	9.47	9.53	9.522	—			
L	7.190	7.210	7.210	—			
M	6.910	6.970	6.945	—			
N	44.47	44.530	44.500	—			
O	6.590	6.650	6.620	—			
P	0.940	0.980	0.958	—			
Q	18.97	19.03	19.00	—			
R	0.350	0.410	0.385	—			
S	0.740	0.780	0.754	—			
T	0.240	0.280	0.250	—			
U	0.370	0.410	0.384	—			
V	0.740	0.780	0.768	—			
W	0.740	0.780	0.754	—			

Measured by: Ep	Audited by: ml	Prototype Approval:	N/A
Date: 06/10/05	Date: 06/00/06	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	03.09.22	New Issue P/O D205-564-011 & D430-688-011	KJ/RF	
B	05.06.15	Dimensions and tolerances changed	KJ/RF	
C	06.08.31	Dimensions updated per D2521 Rev. J	KJ/JLM	

DART

DESIGN #	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED CP	APPROVED #	DRAWING NO. D2521	REV. J SHEET 1 OF 3
DATE 06.07.28		TITLE 205 BEARPAW	SCALE NTS
A	95.11.28	NEW ISSUE	
B	96.01.11	SHOW BENDING MOVE HOLES	
C	96.01.29	ADJUST HOLE LOCATION FOR TOOLING	
D	96.05.14	ADJUSTED BEAR PAW THICKNESS	
E	96.12.18	43.500 WAS 46.750	
F	97.05.07	ADDED REAR POCKET, MOVED HOLES	
G	98.08.06	ADD C'BORE AND CHAMFER EDGES	
H	03.01.30	CHANGE GEOMETRY FOR RUN-ON LDG.	
I	05.05.20	REMOVE BEND; CHANGE TOLERANCES	
J	06.07.28	CHANGE FOR FLOAT SKIDTUBE	

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WITHOUT NOTICE
WORK ORDER
NO. 28729

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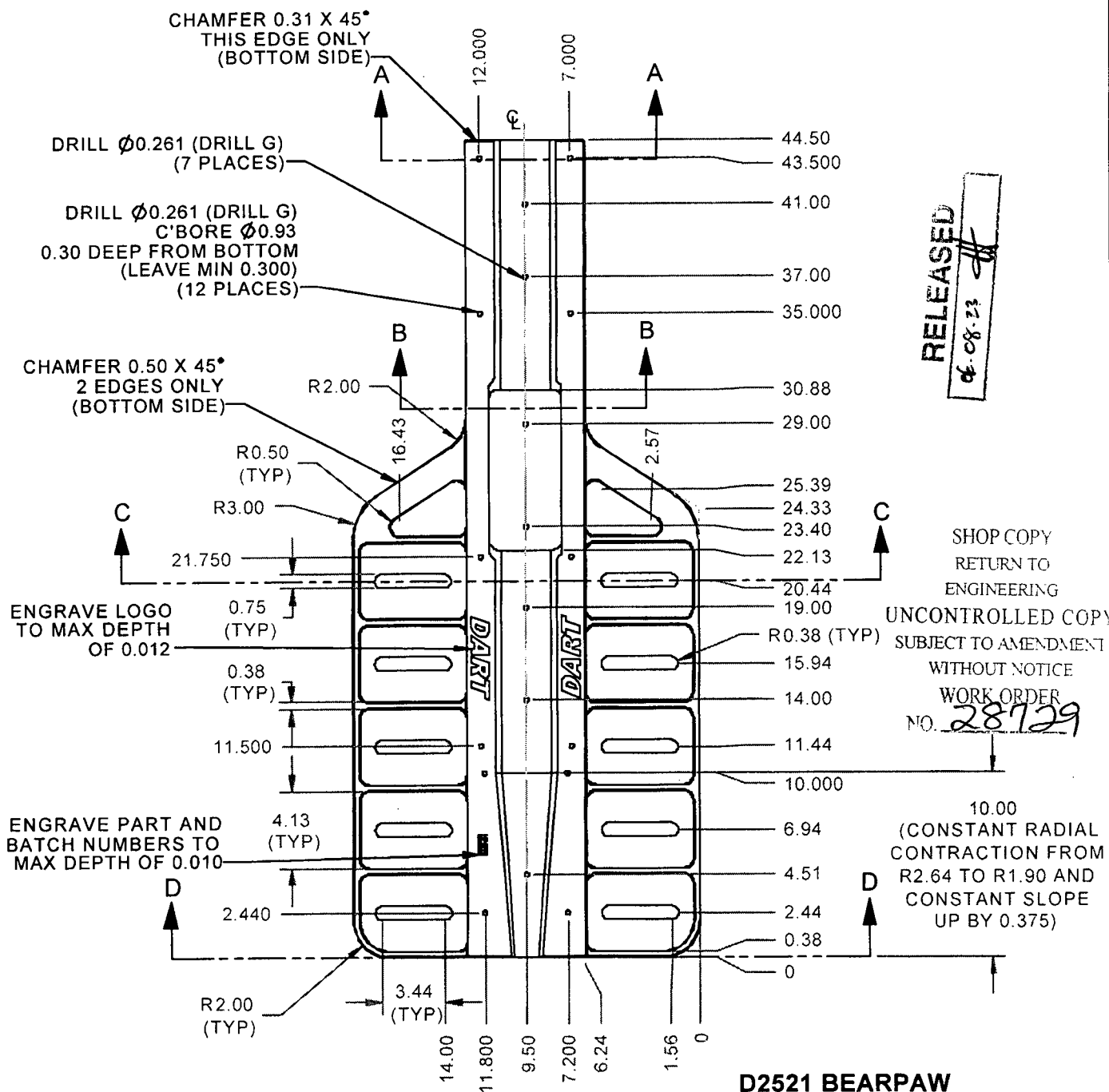
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DART

DESIGN #	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED CP	APPROVED [Signature]	DRAWING NO. D2521	REV. J
DATE 06.07.28	TITLE 205 BEARPAW	SHEET 2 OF 3	
		SCALE 1:8	

**NOTES:**

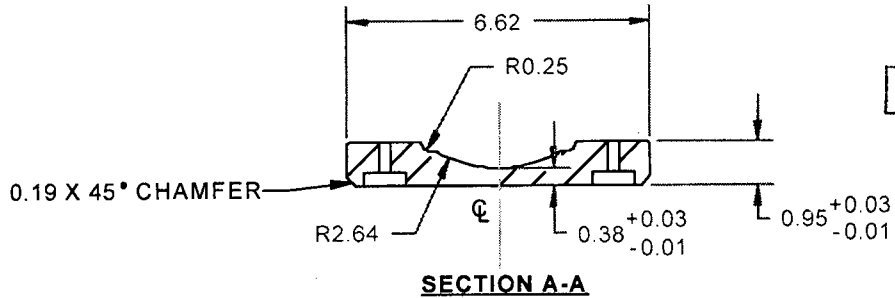
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- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.030
- 6) PART IS SYMMETRIC ABOUT C

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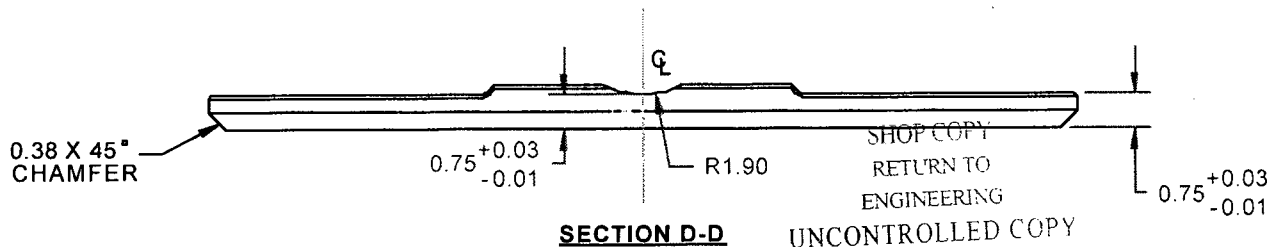
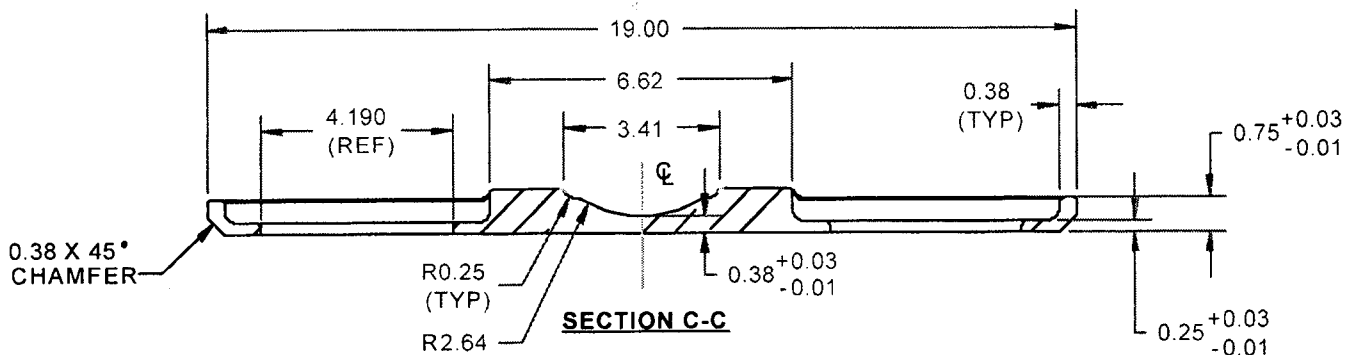
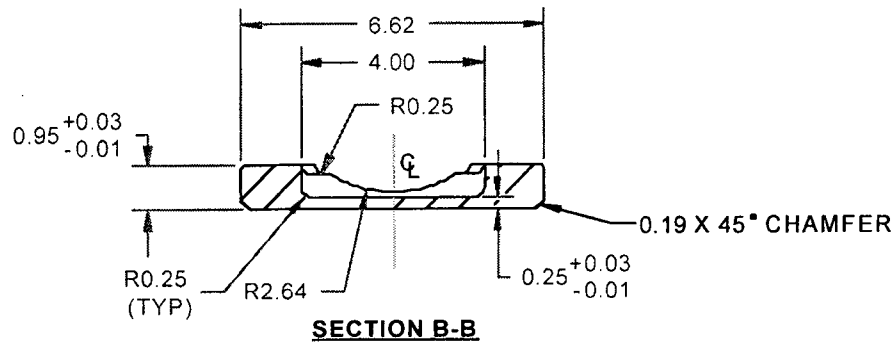
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DESIGN #	DRAWN BY C.B.	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED UP	APPROVED #	DRAWING NO. D2521	REV. J SHEET 3 OF 3
DATE 06.07.28	TITLE 205 BEARPAW		SCALE 1:4

**RELEASED**

06.08.23 #



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